

32

| | | | |
|---|--|---------------------|--------|
| DART AEROSPACE LTD | | Work Order: | 19376 |
| Description: Bearpaw Kit (19" x 16") | | Part Number: | K10007 |
| Dwg: D2435 Rev. E1 | | Qty: | 10 |
| Page 1 of 1 | | | |

| Step | Location | Procedure | By | Date | Qty | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
|------|-------------------------------|---|------------------------|-------------|-------------|-------|---|-----------|----------------|--------|---|-------|--------------|--------|---|-------|---------|--------|---|-------|-------|--------|---|-------|--------|--------|---|---------|------|--------|---|---------|------|--------|----|------------|--------|--------|---|-----------|-------------|--------|---|-----------|-------|---------------------|---|-------------------------------|--|--|---|----------|----|
| 1 | DC | Issue Traveler Note: (1) K10007 Kit consists of Qty (2) D2435 Dwg not required | JA | 03.07.07 | 10 | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| 2 | DC | Photocopy bluefile: K10007 D206-559 D500-572 D120-638 D058-678 and create labels per PPP K10007 CHG003 (Bag Bluefiles separately) | For KJ WK 30 | 03-07-16 | 10 | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| 3 | GA | Cut 2 blanks per K10007 Kit Cut blank: 16.00" x 20.00" x 1.00" thick Material: Black UHMW 1" (MUHMWB10) Identify as D2435 | M1358 Batch: M12812 | 03/08/07 | 10 | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| 4 | MV | Inspect material for defects or damage prior to machining | JA | 03/08/11 | 10 | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| 5 | MV | Machine as per Folio D2435 and Dwg D2435 | JA | 03/08/11 | 10 | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| 6 | QC2 | Inspect parts as they come of the CNC machine | JA | 03/08/11 | 10 | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| 7 | MV | Deburr | JA | 03/08/11 | 10 | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| 8 | QC8 & 5 | Second inspection | EC | 03-08-13 | 10 | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| 9 | KP | Pick: Packing Kit (Note: D2435 is not on the BOM, but is in as material from step 3) <table><thead><tr><th>Qty</th><th>Part Number</th><th>Description</th><th>Batch</th></tr></thead><tbody><tr><td>4</td><td>D2182B050</td><td>Rubber Cushion</td><td>B18914</td></tr><tr><td>8</td><td>D2274</td><td>Radius Block</td><td>B19007</td></tr><tr><td>2</td><td>D2435</td><td>Bearpaw</td><td>B19376</td></tr><tr><td>4</td><td>D2438</td><td>Clamp</td><td>B18915</td></tr><tr><td>8</td><td>D2529</td><td>Washer</td><td>B18539</td></tr><tr><td>8</td><td>AN4-15A</td><td>Bolt</td><td>M13437</td></tr><tr><td>8</td><td>AN4-17A</td><td>Bolt</td><td>M12642</td></tr><tr><td>16</td><td>AN960JD416</td><td>Washer</td><td>M13356</td></tr><tr><td>8</td><td>MS21042L4</td><td>Nut (or -4)</td><td>M12020</td></tr><tr><td>2</td><td>QS200M44S</td><td>Clamp</td><td>M13043-M1003-M13536</td></tr><tr><td>1</td><td colspan="3">Paperwork package from Step 2</td></tr></tbody></table> | Qty | Part Number | Description | Batch | 4 | D2182B050 | Rubber Cushion | B18914 | 8 | D2274 | Radius Block | B19007 | 2 | D2435 | Bearpaw | B19376 | 4 | D2438 | Clamp | B18915 | 8 | D2529 | Washer | B18539 | 8 | AN4-15A | Bolt | M13437 | 8 | AN4-17A | Bolt | M12642 | 16 | AN960JD416 | Washer | M13356 | 8 | MS21042L4 | Nut (or -4) | M12020 | 2 | QS200M44S | Clamp | M13043-M1003-M13536 | 1 | Paperwork package from Step 2 | | | Q | 03-08-20 | 10 |
| Qty | Part Number | Description | Batch | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| 4 | D2182B050 | Rubber Cushion | B18914 | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| 8 | D2274 | Radius Block | B19007 | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| 2 | D2435 | Bearpaw | B19376 | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| 4 | D2438 | Clamp | B18915 | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| 8 | D2529 | Washer | B18539 | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| 8 | AN4-15A | Bolt | M13437 | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| 8 | AN4-17A | Bolt | M12642 | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| 16 | AN960JD416 | Washer | M13356 | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| 8 | MS21042L4 | Nut (or -4) | M12020 | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| 2 | QS200M44S | Clamp | M13043-M1003-M13536 | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| 1 | Paperwork package from Step 2 | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| 10 | QC4 | Inspect Kit for 100% Completeness on the W/O | LL | 03-08-25 | 10 | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| 11 | PK | Identify and pack for shipping as per PPP K10007 | REV D | 03-08-26 | 10 | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| 12 | AC | Cost / part 112.06 | 545 | 03-08-27 | 10 | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| 13 | DC | Close W/O 122.44 Inspect Level 21 | JA | 03.08.27 | - | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |

| Rev | Date | Change | Revised By | Approved |
|-----|----------|--|------------|----------|
| A | 99.12.17 | K10007 created for Bear paw kit (MPP 2000) | EC | |
| B | 01.03.21 | Added OH-58 paperwork (MPP 2092) | EC | |
| C | 01.11.08 | Revised Step 3 and Added Level 21 | SM | |
| D | 03.03.26 | Reformat; Incorporated D2435 | KJ/RF | |

BB 03-08-27 BB

RELEASED
03.03.31 RF

| Work Order: | | WORK ORDER CHANGES | | | | | |
|-------------|------|--------------------|----|------|-----|-----------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Manuf / Design Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

| NCR | | WORK ORDER NON-CONFORMANCE | | | | | | |
|------|------|--------------------------------|---------|--------------------------------|----------------|---------------------------|------------------------|--------------------------|
| DATE | STEP | Description of NC section A | Initial | Corrective Action Section B | Sign & Date | Verification Section C | Approval Design Mgr | Approval QC Inspector |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

PAR#: _____ Fault Category: _____ DQA: _____ Date: _____

NOTE: Date & initial all entries
H:\Admin-QA\ISO\forms\w\oncb.doc

QA: N/C Closed: _____ Date: _____

Job Costing Report

Dart Aerospace Ltd.
Hawkesbury

Jul 07, 2003
11:38 am

| | | | |
|-------------------|-------------------------|------------------------------|----------------|
| Work Order No | : 0019376 | Department Code: | |
| Project Name | : *K10007 | Burden Flags | : NNNNNNN |
| Project For | : WK332 | WO Status | : Open |
| Work Order Type | : Main | Invoice State | : Not Invoiced |
| Main WO Number | : | Invoice Date | : |
| House Part Number | : *K10007 | Invoice Number | : |
| Description | : Bearpaw Kit 19" x 16" | Invoice Amount | : 0.00 |
| Manufactured | : Yes | Order Entry No | : |
| Amount Req'd | : 10 | OE Value | : 0.00 |
| Amount Done | : 0 | Est Margin | : 0.000% |
| Start Date | : 07-07-03 | Actual Margin | : 0.000% |
| Est Finish Date | : 08-06-03 | | |
| Act Finish Date | : | | |
| Drawings Req'd | : No | | |
| Ok for Approval | : | | |
| Approval Rec'd | : | \$0 Posted to Finished Goods | |

| | Estimated | Actual | Var. % | Posted | To Post |
|-------------------|-----------|--------|--------|--------|---------|
| Material Cost | : 0.00 | 0.00 | 0.00 | 0.00 | 0.00 |
| Engineering Hours | : 0.00 | 0.00 | 0.00 | | |
| Engineering Cost | : 0.00 | 0.00 | 0.00 | 0.00 | 0.00 |
| Production Hours | : 0.00 | 0.00 | 0.00 | | |
| Production Cost | : 0.00 | 0.00 | 0.00 | 0.00 | 0.00 |
| Testing Hours | : 0.00 | 0.00 | 0.00 | | |
| Testing Cost | : 0.00 | 0.00 | 0.00 | 0.00 | 0.00 |
| OverHead Hours | : 0.00 | 0.00 | 0.00 | | |
| OverHead Cost | : 0.00 | 0.00 | 0.00 | 0.00 | 0.00 |
| SubContract Hours | : 0.00 | 0.00 | 0.00 | | |
| SubContract | : 0.00 | 0.00 | 0.00 | 0.00 | 0.00 |
| Misc. Hours | : 0.00 | 0.00 | 0.00 | | |
| Misc. | : 0.00 | 0.00 | 0.00 | 0.00 | 0.00 |
| Burden | : 0.00 | 0.00 | 0.00 | | |
| Total Cost | : 0.00 | 0.00 | 0.00 | | |
| Margin | : 0.000 | 0.000 | | | |
| Selling Cost | : 0.00 | 0.00 | | | |

| | Estimated | Actual |
|------------------------|-----------|--------|
| Labour Hrs/Amount Done | : 0.00 | 0.00 |
| Profits/(Loss) | : 0.00 | 0.00 |



Dart Aerospace, Ltd
1270 Aberdeen Street
Hawksbury, Ontario
K6A 1K7
Tel: (613) 632-3336 Fax: (613) 632-4443

Supplier Code: _____ Sheet ____ of ____

INSPECTION CHECKLIST

PART NO.: D2435

PHY. CHANGE: _____

DESCRIPTION: BRACKET

DRAWING CHANGE: REV E

MANUFACTURING DATE: 03/08/11

UNICORP E.O.'S: _____

BATCH NO.: 19376

SERIAL NO.: _____

PURCHASE ORDER NO.: _____

QUANTITY ACPT. _____ REJ. _____

DATA SHEET NO.: _____

☒ FIRST ARTICLE ☐ PERIODIC CONFORMITY ☐ FINAL INSPECTION

| ITEM | DWG PAGE | DRAWING DIMENSION | TOL. | ACTUAL DIMENSION | ACC. | REJ. | % OF INSP. | Method of Inspection | Comments |
|------|----------|-------------------|-------|------------------|------|------|------------|----------------------|-----------------|
| 1 | 1 | 0.260 | ±0.03 | 0.261 | ✓ | | 100% | Vern | |
| 1 | 1 | 0.13 | ±0.03 | 0.135 | ✓ | | | Vern | |
| 1 | 1 | 0.30 | ±0.03 | 0.309 | ✓ | | | O-Mic | |
| 1 | 1 | 0.35 | ±0.10 | 0.381 | ✓ | | | Vern | |
| 1 | 1 | 4.75 | ±0.10 | 4.811 | ✓ | | | Vern | OK. RF 03.08.11 |
| 1 | 1 | 2.500 | ±0.05 | 2.500 | ✓ | ✓ | | O-Mic | |
| 1 | 1 | 4.250 | ±0.05 | 4.253 | ✓ | | | Vern | |
| 1 | 1 | 2.000 | ±0.00 | 1.996 | ✓ | | | Vern | |
| 1 | 1 | 11.000 | ±0.10 | 10.996 | ✓ | | | Vern | |
| 1 | 1 | 15.750 | ±0.10 | 15.766 | ✓ | ✓ | | Vern | OK. RF 03.08.11 |
| 1 | 1 | 19.000 | ±0.10 | 19.005 | ✓ | | | Vern | |
| 1 | 1 | 0.63 | ±0.03 | 0.60 | ✓ | | | Vern | |
| 1 | 1 | 5.300 | ±0.10 | 5.296 | ✓ | | | Vern | |
| 1 | 1 | 11.200 | ±0.10 | 11.19 | ✓ | | | O-Mic | |
| 1 | 1 | 0.35 | ±0.03 | 0.350 | ✓ | | | Vern | |
| 1 | 1 | 0.350 | ±0.10 | 0.353 | ✓ | | | Vern | |
| 1 | 1 | 0.625 | ±0.03 | 0.623 | ✓ | | | Vern | |
| 1 | 1 | 0.950 | ±0.03 | 0.951 | ✓ | | | Vern | |
| 1 | 1 | 0.375 | ±0.03 | 0.375 | ✓ | | | Vern | |

H:\admin-galis\forms\first article inspectionA

Rev. B

Measured by: [Signature]

Audited by: [Signature]

Approved by: RF 03.08.11